












Date: Thursday, 4/6/2006 9:33:48 AM
 User: Linda Lacelle

Process Sheet

Customer : GU-DAR001 Dart Helicopters Services		Drawing Name : MOUNTING LUG	
Job Number : 26593		Part Number : D22303	
Estimate Number : 10256		Drawing Number : D2230 REV F	
P.O. Number : N/A		Project Number : N/A	
This Issue : 4/6/2006 S.O. No. : N/A		Drawing Revision : F	
Prsht Rev. : NC		Material : N/A	
First Issue : N/A Type : MACHINED PARTS		Due Date : 4/13/2006	
Previous Run : 26203		Qty: 271 300 Um: Each	
Written By : <u>SEE COMMENT BELOW</u>			
Checked & Approved By : <u>u</u>			
Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC			
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
			
Comment: Qty.: 0.0717 f(s)/Unit Total : 21.5145 f(s) Lug Extrusion D2423 Batch: <u>23779</u> <u>M8/5.G 06/04/07</u> <u>271</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <u>23779</u> <u>M8/5G 06/04/07</u>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. <u>PG issue 8.0</u> <u>974</u> <u>C206/04/10</u> <u>Notec</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>PG receive + inspect for transport damage</u> <u>06/04/07</u>			
5.0	QC5	SECOND CHECK	
			
Comment: SECOND CHECK <u>06.05.04</u> <u>AS per Q51 019</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *SD* Date: 06/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Thursday, 4/6/2006 9:33:49 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 26593

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

N/A

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HM 06-05/04

271

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206.05.06

271

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06/05/06

271

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

LC 4/5/8

271

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57371

LC 4/5/9

(271)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

206/05/09

(271)

Job Completion



LC 26.05.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

271

D22303

Mounting Lug

974

MATERIAL: supplied by DART ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, April 27, 2006

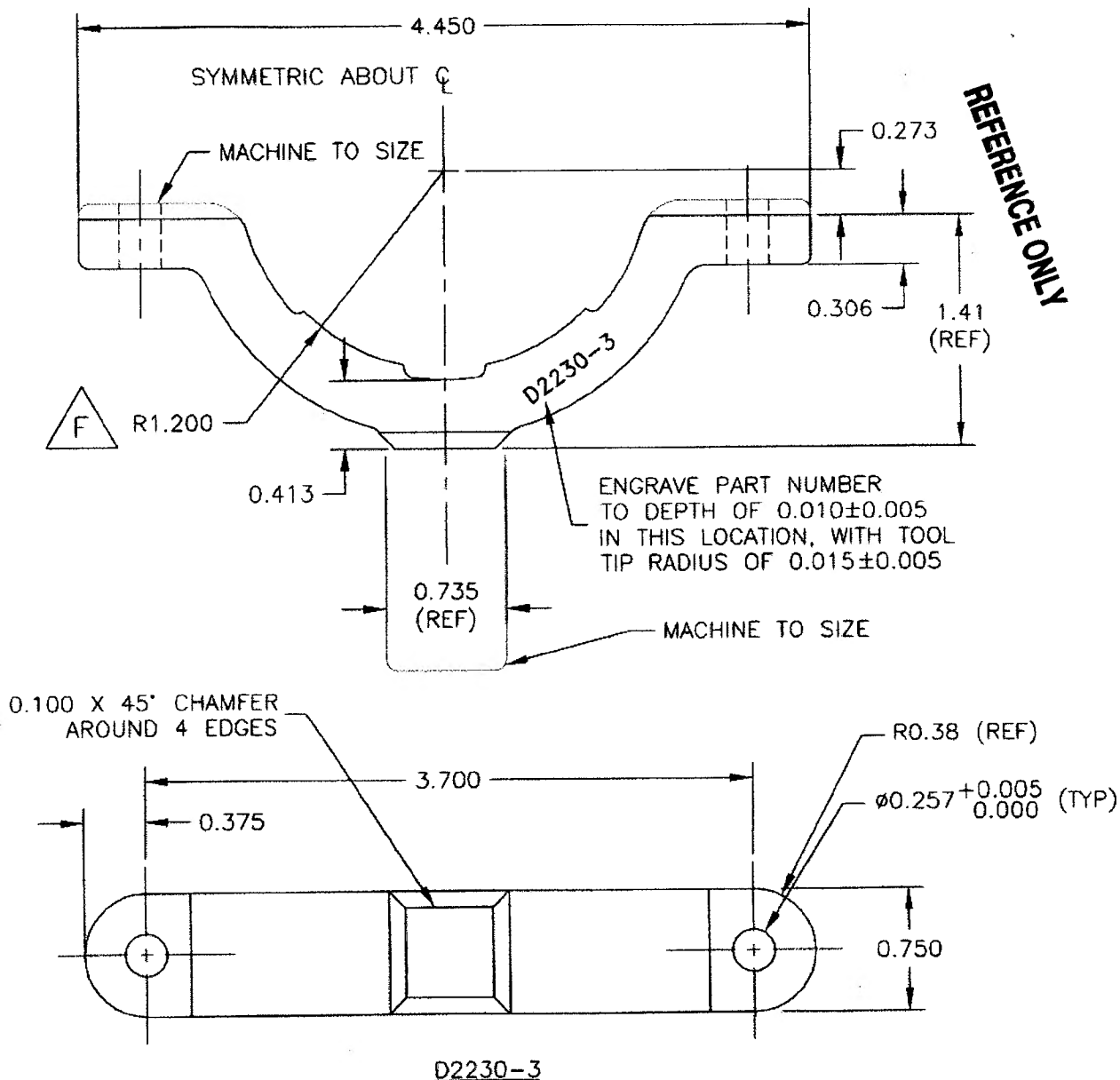
SL
06/04/27

06-05-03



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED